

Work Order ID 152512

Thursday, October 27, 2016 7:06:31 AM

152512

Page 1

Item ID: 650.0401 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: PUREair Fairing Assembly
Start Date: 10/27/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/10/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
650.0400									

110

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 32043

Description: 650.0401

Supplier: FDC

Certification of Conformity and process sheet from FDC is required.

0.00

0.00

W 16/04/14

120

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure Certificate of Conformity & Process Sheet are attached

0.00

0.00

IX SP17-02-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo Inspect as per Dwg 650.0401 Audit process sheet. <i>SMALL FAB. Remove & Replace all Hardware. FB/09</i>	0.00 0.00				1			<i>38 9-89</i> P.T.O. FEB 23 2017 DAS 07 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>FB/09</i> Memo	0.00 0.00				<i>1</i> DAS 6 9-89		<i>28</i> 2017 <i>17/02/23</i>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02						<i>17/2/28</i> <i>9-89</i>	<i>17/02/23</i> DAS 21 9-89 FEB 28 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, October 27, 2016 7:06:30 AM

Page 1
T

Work Order ID: 152512

152512

Parent Item: 650.0401

650 0401

Parent Item Name: PUREair Fairing Assembly

Start Date: 10/27/2016

Required Date: 11/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

650.0401P

Purchased

No

Each

0.0000

1

650 0401P

AS350 Eaps Fairing Assembly

**

1x SP17-02-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.		04939		SHEET 1 OF 1					
DWG NO.	650.0400	REV:	C	PREPARED BY	J. SOTO	DATE:	04/28/2015	EFFECT ON DWG	☒ INC. ☐ UNINC.
DWG TITLE:		AS350 EAPS FAIRING ASSY							
APPROVED BY:	ENGR <i>[Signature]</i>	MFG	<i>[Signature]</i>	QC	<i>[Signature]</i>	EFF. NEXT ORDER			
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: REVISED F/N 4, 5, 6, & 9 FROM IMPERIAL TO METRIC.								

W/0152512

9	R	601.3803	2	SCREW	LN9038-05-16	
6	R	601.3802	14	CLICK BOND, NUTPLATE	CB6014CR5M-1P	
5	R	601.3801	12	SCREW	LN9038-05-14	
4	R	601.3800	14	WASHER	BS4320-A5	
F/N	TC	PART NUMBER	.0401			
		QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: ☐ PATTERN ☐ MDL ☒ INSTALL INSTRUCTIONS ☒ ICA ☐ FMS ☒ BOM						
CHANGE CATEGORY				DER REVIEW REQUIRED		
☐ MAJOR ☒ MINOR				☐ YES ☒ NO		

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OTHER : _____																																																															

B	G7M26	650.0400	D
SCALE NONE		SHEET 1 OF 4	

DQA: _____ Date: _____



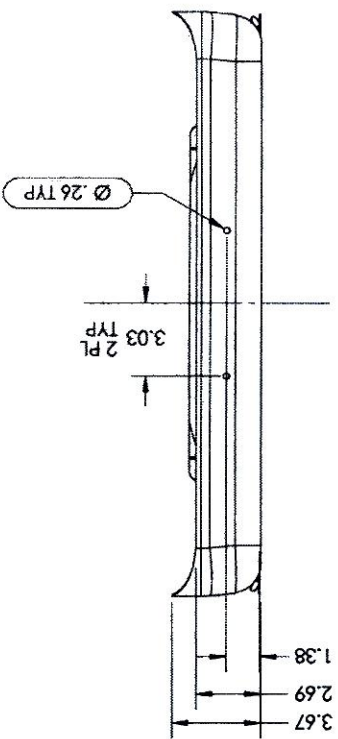
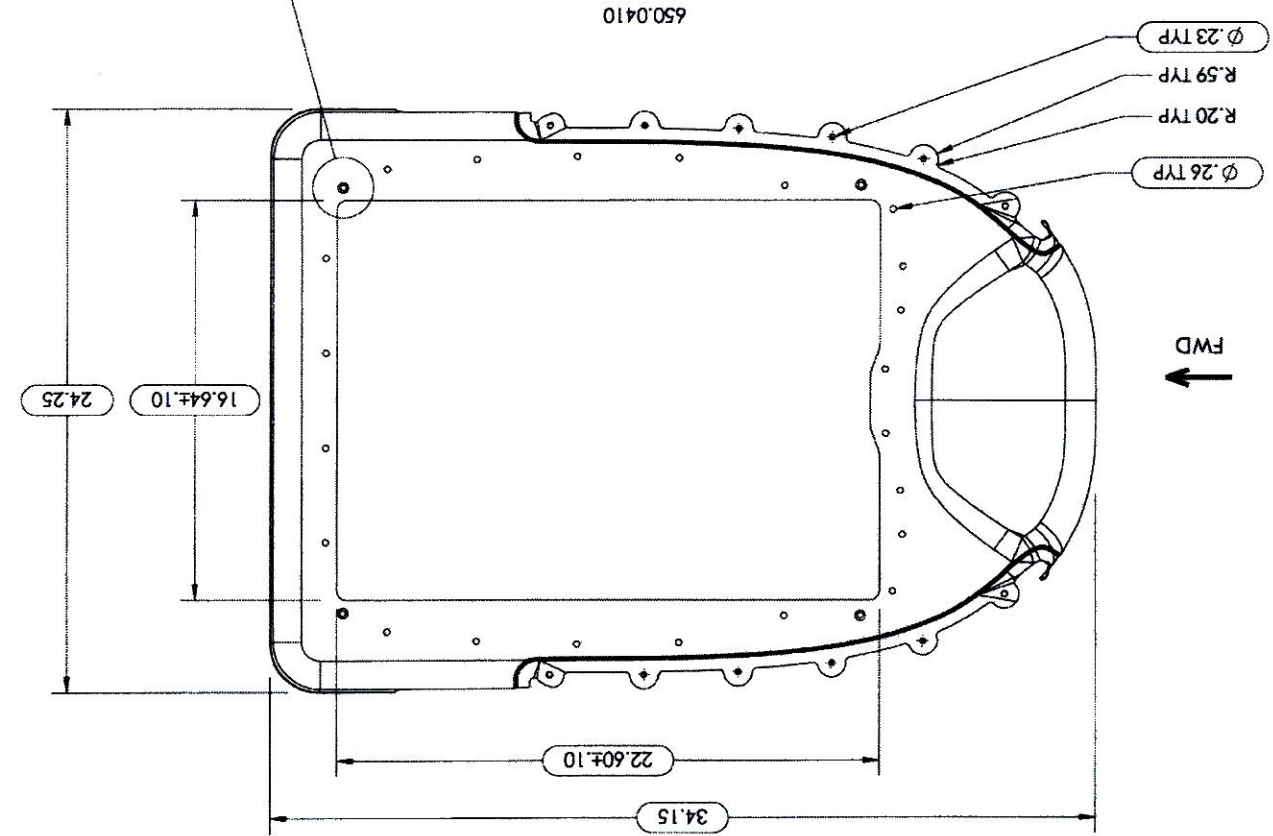
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APICAL INDUSTRIES		OCEANSIDE, CA 92056-3512 (760) 724-5800			
DRAWN BY: CHUCKER		CHECKED BY: L. J. BENDER			
DATE: 07/14/10		CONTRACT NO.:			
REVISIONS:		DATE:			
1. CHANGE APPROVAL		DATE:			
2. CHANGE APPROVAL		SCALE: NONE	SHEET: 2 OF 4		
3. CHANGE APPROVAL					
4. CHANGE APPROVAL		DWG. NO.:		REV.:	
5. CHANGE APPROVAL					
6. CHANGE APPROVAL		650.0400			
7. CHANGE APPROVAL		B 07M26			
8. CHANGE APPROVAL		D			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

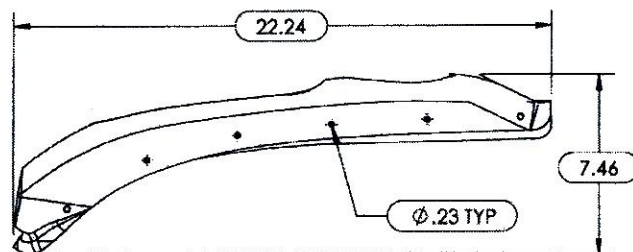
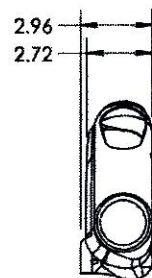
QA Closed: _____ Date: _____

Work Order update only ☐

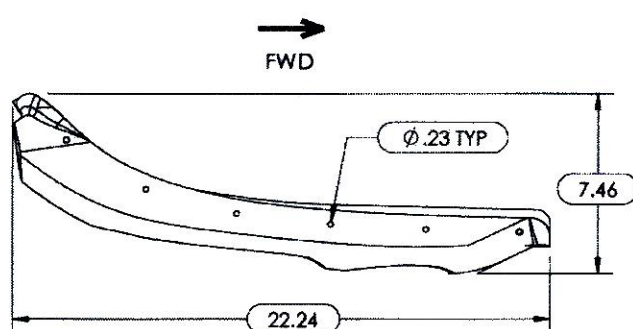
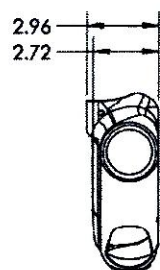
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY						
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
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Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process								
Misidentified ☐	☐	Past Due								
			OTHER : _____							

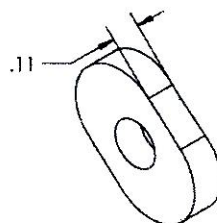
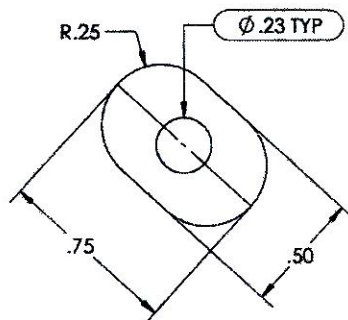
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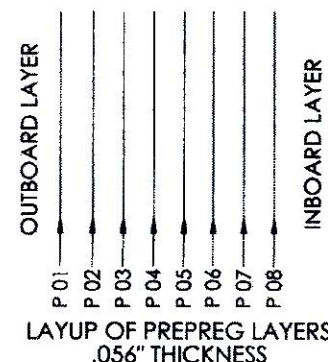
650.0411



650.0412



650.0415



LAMINATE 1 - .056" (6 LAYERS CARBON FIBER)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	NA	△	.004"
02	NA	△	.004"-.012"
03	0	△	.008"-.010" PER LAYER
04	90	△	
05	0	△	
06	90	△	
07	0	△	
08	90	△	

ORIGINAL DATE 07/16/13		APICAL INDUSTRIES	
DRAWN BY CHECKER		2608 TEMPLE HEIGHTS DR.	
D. PETERS		OCEANSIDE, CA, 92056-3512 (760)724-5300	
DRAWING APPROVAL		AS350 EAPS FAIRING ASSY	
J. GARDNER		REV D	
SCALE NONE		SHEET 3 OF 4	

DQA: _____ Date: _____



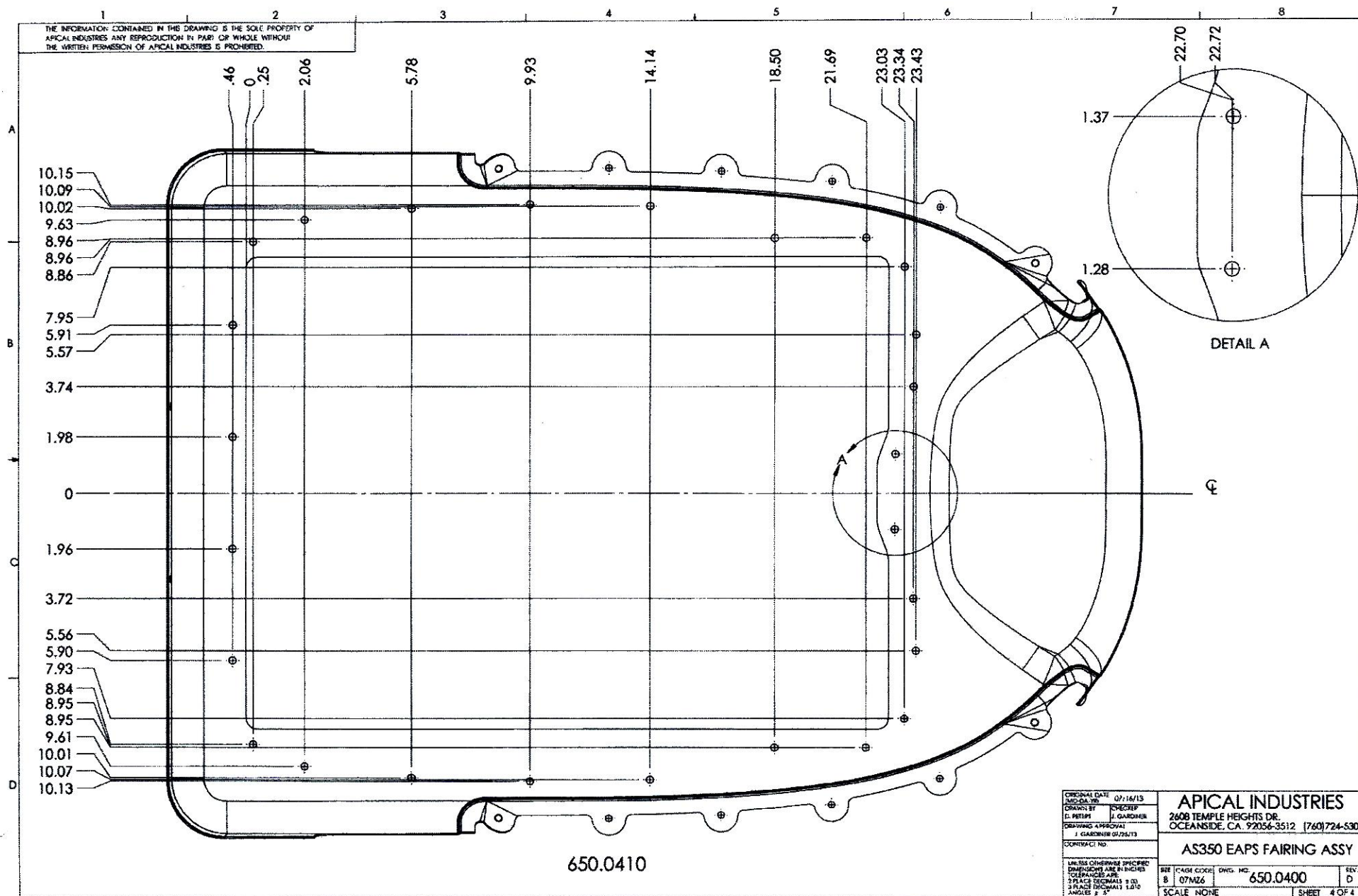
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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ORIGINAL DATE 07/16/13		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR.	
C. RETUP		OCEANSIDE, CA. 92056-3512	
DRAWING APPROVAL J. GARDNER 01/25/13		(760) 724-5300	
CONTRACT NO.		AS350 EAPS FAIRING ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		REV. D	
SIZE B	CAGE CODE 07M26	DWG. NO. 650.0400	
SCALE NONE			SHEET 4 OF 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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							QC / QA Coordinator Approval																		

Root Cause				FAULT CATEGORY			
Environment ☐			No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐			Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐			Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐			Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐			Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐			Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐			Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐			Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐			Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐			Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐			Manufacturing Process ☐	OTHER : _____			
Misidentified ☐			Past Due ☐				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID POS2016

Purchase Order Date 4/14/2016
PO Print Date 10/27/2016

Page Number 3 of 8

VU-FDC001

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Order From:
FDC COMPOSITES INC
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST. JEAN SUR RICHELIEU, QUEBEC J3B 7B5

Contact Name
Vendor Phone 450-357-1344 Ext 303

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Chantal Lavoie
Customer POID 10127-2607
Customer Tax # Net 30
Terms USD
Currency Destination-Collect
FOB

		Line Total:		\$2,580.00
8	650 0401P ✓	AS350 Eaps Fairing Assembly	1.00 ✓ Each	\$2,580.00
		11/10/2016	No	
		11/10/2016		
		Line Total:		\$2,580.00
		AS PER DWG 650 0401		
		B152509 ✓		
9	650 0401P ✓	AS350 Eaps Fairing Assembly	1.00 ✓ Each	\$2,580.00
		11/10/2016	No	
		11/10/2016		
		Line Total:		\$2,580.00
		AS PER DWG 650 0401		
		B152510 ✓		
10	650 0401P ✓	AS350 Eaps Fairing Assembly	1.00 ✓ Each	\$2,580.00
		11/10/2016	No	
		11/10/2016		
		Line Total:		\$2,580.00
		AS PER DWG 650 0401		
		B152512 ✓		

SP17-01-25

SP17-02-6

PO Instructions: QUOTE NO. 1239
Note:

10/27/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel. : 450 357-1344

Shipping Order 03/02/2017

Order : 5765 Rev F
Reference : PO #32043/1
Ship : FOB USINE FDC PLANT

Customer: DART US

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON
K6A 1K7

Ship To
Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
650.0401 ✓	PUREair Fairing Assembly PO item: 32043/1 Lot:2016-12-01 Lot: 2016-11-28 Lot: 2016-11-07 FDC ID:DAE009-008 ✓ FDC ID:DAE010-007 ✓ FDC ID: DAE011-009 ✓ Lot: 2017-01-10 Lot:2017-01-04 Lot: 2017-01-12 FDCID:DAE009-012 FDCID:DAE010-011 FDCID: DAE011-012 Lot:2016-12-20 Lot:2017-01-10 Lot:2017-01-04 FDCID:DAE009-011 FDCID:DAE010-012 FDCID:DAE011-011	10	3	0

SP 17-02-6

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

CERTIFICATE OF CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 32043

Revision : NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number ID</u>	<u>Description</u>	<u>Dwg number Assy</u>	<u>FDC ID</u>	<u>Lot</u>
1	3 (Number 8,9 and 10)	650.0401	PUREair Fairing Assembly	650.0400 Rev D	DAE009-008	2016-12-01
					DAE010-007	2016-11-28
					DAE011-009	2016-11-07
					DAE009-012	2017-01-10
					DAE010-011	2017-01-04
					DAE011-012	2017-01-12
					DAE009-011	2016-12-20
					DAE010-012	2017-01-10
					DAE011-011	2017-01-04

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Karim Malihi, Quality Manager

Date: 03 Feb 2017



Supplier Non-Conformance Report

Reviewed			
DQA:			
Date:			
Details			
Raised Date 2/8/2017	Status Open	Owner Downing, Eric M	Number NCR17-6272
Target Date 2/17/2017	Standard	Severity MAJOR	
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) FDC Composites Inc.		Fault Category Supplier
Details It was brought to the attention of Dart inspector that FDC on PO32043 that the hardware being installed on the 650.0401 fairing are not to the current drawings. FDC is installing hardware according to the Rev B drawing instead of the Rev D drawing. They are manufacturing the parts per Rev D but installing the old hardware. Also has been noticed that FDC is supplying Dart with a C of C that states Rev D but there process sheets states that the parts are manufactured to Rev B.			
Keywords wrong hardware		Product 650.0401	
Document		Root Cause Data/Documentation	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 2/17/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	2/10/2017	
Contact FDC regarding to why wrong hardware is being used.		see attached email	
2	Duval, Patrick	2/10/2017	2/9/2017
put all FDC 650.0401 Fairings in manufactured with the REV B parts in quarantine		650.0401 qty3 from PO32043	
3	Downing, Eric M	2/13/2017	2/15/2017
get approval if the use of REV B hardware is acceptable or to have all parts returned to FDC for reworking.		as per attach email rev B hardware is not acceptable. Parts will need to be ship back to FDC for rework	

4	Lacelle, Linda	2/10/2017	2/9/2017
ensure that all PO's are updated to have the correct drawing Revision on them		see attached doc titled Update to PO's (RevD)	
5	Lacelle, Linda	2/17/2017	2/21/2017
return to FDC to reworks 650.0400 as per rev.D. FDC to remove existing nutplate and replace with 601.3802 rev.D. Also screws will need to be replace for 601.3803/601.3801 rev.D		rework will to done at Dart	
6	Leger, Daryl	2/23/2017	
disassemble 650.0401, remove and scrap non conforming nutplates and screws. Rework EASP fairing to rev D using correct hardware:click bond nutplate 601.3802,screws 601.3803 and 601-3801, washer 601.3800		click bond nutplate 601.3802 qty14 M_____screws 601.3803 qty2 M_____screws 601-3801 qty12 M_____ washer 601.3800 qty14 M_____	

Verification & Review

Target Date	Owner	Closed Date	Closed By
2/17/2017	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details	Response		